

# Work Order ID 82502

\*82502\*

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April 2, 2012 7:10:38 AM

Item ID: D3996-FE-832-EF

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Self-Clinching Fastener

Start Date: 4/02/12 Start Qty: 200.00

\*200\*

Cust Item ID:

Required Date: 4/06/12 Req'd Qty: 200.00

\*200\*

Customer:

Reference:

Approvals:

Process Plan:

CL

Date:

12/04/02

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3996

A

100

0.00

\*100\*

Purchasing

Memo

0.00

Purchasing

Issue P/O:

16615

Purchase Part Number: FE-832-EF

Supplier: Interfast Inc.

Certificate of conformity is required

CL 12/04/02

110

Receive & Inspect for Damage & Mat'l Certs

0.00

\*110\*

Packaging

Memo

0.00

Packaging

CL 12/7/12 (200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 82502

\*82502\*

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Item ID: D3996-FE-832-EF

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Self-Clinching Fastener

Start Date: 4/02/12 Start Qty: 200.00

\*200\*

Cust Item ID:

Required Date: 4/06/12 Req'd Qty: 200.00

\*200\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

\*120\*

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location

0.00

\*130\*

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

7700  
as per 15

200  
12/4/10

12/4/10

12/4/10

12-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82502

Parent Item: D3996-FE-832-EF

Parent Item Name: Self-Clinching Fastener

Start Date: 4/02/12

Required Date: 4/06/12

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP RevA: new issue 09.11.11 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-832-EF PEM Insert		Purchased	No			110	Each	0.0000	1	200		4/4/12	200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

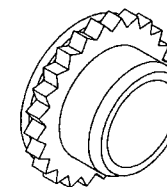
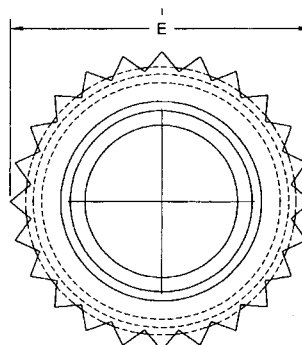
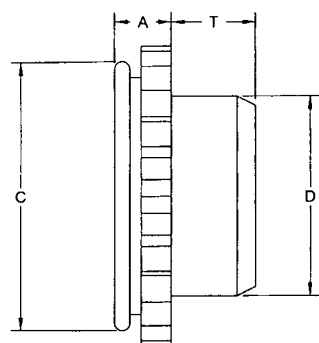
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# SPECIFICATION CONTROL DRAWING



## D3996-XXX-YYY-ZZZ SELF-CLINCHING FASTENER

THREAD SIZE	THREAD CODE ("YYY")	TYPE ("XXX")	A MAX (SHANK)	SHEET THICKNESS	C +0.000 -0.005	D MAX	E +0.005	T +0.015 -0.000	HOLE SIZE IN SHEET +0.003/-0.000	MIN DIST: HOLE CL TO EDGE	WEIGHT lb
#4-40 (0.112)	440	FEO	0.040	0.039-0.045	0.171	0.145	0.192	0.065	0.172	0.14	0.00031
		FE	0.060	0.059-0.070							0.00037
#6-32 (0.138)	632	FEO	0.040	0.039-0.045	0.212	0.180	0.244	0.075	0.213	0.17	0.00047
		FE	0.060	0.059-0.070							0.00068
#8-32 (0.164)	832	FEO	0.040	0.039-0.045	0.289	0.215	0.322	0.090	0.290	0.20	0.00098
		FE	0.060	0.059-0.070							0.00124
#10-32 (0.190)	032	FEO	0.040	0.039-0.045	0.289	0.245	0.322	0.110	0.290	0.20	0.00104
		FE	0.060	0.059-0.070							0.00120
1/4-28	0428	FE	0.060	0.059-0.070	0.343	0.318	0.384	0.120	0.344	0.28	0.00158

### NOTES

1) SPECIFICATION: PENNENGINEERING (PEM) MINIATURE SELF-CLINCHING FASTENER, SELF-LOCKING  
PEM P/N XXX-YYY-ZZZ

WHERE "XXX" = TYPE "FEO" (SHORT SHANK) OR "FE" (LONG SHANK) PER TABLE

"YYY" = THREAD CODE PER TABLE

"ZZZ" = FINISH CODE PER NOTE 2 BELOW

FOR EXAMPLE, #8-32 THREAD, LONG SHANK, ELECTRO-FILM FINISH:

DART P/N = D3996-FE-832-EF

PEM P/N = FE-832-EF

2) FINISH: FINISH CODE ("ZZZ") PER THE FOLLOWING:

"C" = CADMIUM YELLOW CHROMATE PER ASTM B766 CLASS 5 TYPE II

"CI" = CADMIUM CLEAR CHROMATE PER ASTM B766 CLASS 5, TYPE III

"EF" = ELECTRO-FILM PER MIL-PRF-46010

"MD" = MOLYBDENUM DISULFIDE DRY FILM (STD PEM FINISH)

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

C212108102

W10' 8 2502

RELEASED  
2009-11-08

A	NEW ISSUE	CP	09.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D3996	SHEET 1 OF 1
TITLE	SELF-CLINCHING FASTENER	SCALE NTS
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO16615

Purchase Order Date 4/02/12

PO Print Date 4/02/12

Page Number 1 of 1

Order From :

VC-INT001

INTERFAST INC.  
6360 COTE DE LIESSE  
MONTREAL, QC H4T 1E3  
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	5147385959	Requisition Nbr	
Vendor Fax	5147386363	Tax Resale Nbr	10127-2607
Vendor Account Nbr	110900	Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	FE-832-EF	PEM Insert	4/05/12 Yes	200.00 Each	FedEx PI collect	\$0.2900	\$58.00

Special Inst: AS PER DWG D3996 REV.A  
B82502

PO Total: \$58.00

Change Nbr: 1

Change Date: 4/02/12

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable





22 WORCESTER ROAD, TORONTO, ON, CAN, M9W 5X2  
TEL: 1-416-674-0770 FAX: 416-674-5804  
WEBSITE: www.interfast.ca

# Packing Slip



03-APR-12

Invoice#:

684387

SV DART AEROSPACE LIMITED  
OE 1270 ABERDEEN ST.  
LN HAWKESBURY ON  
DD K6A 1K7  
U CAN  
T  
OA

SE DART AEROSPACE LIMITED  
HX 1270 ABERDEEN ST.  
IP HAWKESBURY ON  
PD CAN K6A 1K7  
TI  
OE  
R  
A

SHIP MODE: Purolator  
MODE D'EXPEDITION:  
FOB: FOB - Interfast Dock  
F.A.B.:  
NO. CARTONS: 1  
WAYBILL #: NAE100040919  
FACTURE DE VOIE #:

CUSTOMER PO#: PO16615  
N° DU BON DE COMMANDE:

CUSTOMER #: 110900  
CLIENT #:

OUR SALE #: 584810  
N° DE LA VENTE:

TERMS: Net 30 Days (01)  
MODALITES:

QUANTITY ORDERED QUANTITÉ COMMANDÉE	U/M M.N.R.	QUANTITY SHIPPED QUANTITÉ EXPÉDIÉE	BALANCE DUE SOLDE	PART# & DESCRIPTION PARTIE # ET DESCRIPTION	LOT# / Serial#
200.00	EA	200.00	0.00	Cust PO Line#: Cust Part#: FE-832-EF Part#: FE-832-EF Description: NUT ** Packbox#: PACK579823 Lot Line#: 1 Qty: 200 Expire Date Country Of Origin: USA Rev Lvl:	D580370C
Harmonized code:		7318.16.00.90	<i>S</i> <i>12/14/09</i>	Please note this item is NOT RoHS Compliant	

Total Qty Shipped: 200

GST/TPS # R102504958 QPST/TVQ #1009982431TQ0001  
PAST DUE ACCOUNTS WILL BE SUBJECT TO A SERVICE CHARGE OF 1.5% PER MONTH. INTERFAST WILL BE RESPONSIBLE FOR THE AUTHORIZED REPLACEMENT OF GOODS WHICH ARE DEFECTIVE OR WHICH ARE NOT TO SPECIFICATION PROVIDED THAT CLAIMS ARE MADE WITHIN 14 DAYS OF SHIPMENT.

LES COMPTES EN SOUFFRANCE SERONT ASSUJETTIS À DES FRAIS DE SERVICE DE 1.5% PAR MOIS. INTERFAST NE SERA RESPONSABLE QUE POUR L'ÉCHANGE AUTORISÉ DE BIENS DÉFECTUEUX OU QUI NE SONT PAS CONFORMES AUX SPÉCIFICATIONS À CONDITION QUE LES RÉCLAMATIONS SOIENT EFFECTUÉES DANS LES QUATORZE (14) JOURS SUIVANT L'EXPÉDITION.

Dave Dawkins

*Dave Dawkins*  
Manager Of Quality



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"Je certifie par les présentes que les articles ou matériaux couverts par le présent document ont été inspectés, et qu'ils sont conformes à toutes les spécifications applicables en ce qui a trait auxdits articles ou matériaux. À moins d'avoir obtenu l'autorisation du client, aucun remaniement ni aucune modification n'ont été apportés. La documentation de soutien prouvant la conformité se trouve dans le dossier ou est disponible sur demande."

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